

Date: Thursday, 8/30/2007 3:51:23 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 34367		
Estimate Number	: 10530		
P.O. Number	: <u>NIA</u>	Part Number	: D2571
This Issue	: 8/30/2007 S.O. No. : <u>NIA</u>	Drawing Number	: D2571 REV E
Prsht Rev.	: <u>NO</u>	Project Number	: N/A
First Issue	: <u>NA</u> Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 33040	Material	: <u>NA</u>
Written By	: <u>1007.0831</u>	Due Date	: 9/21/2007 Qty: 8 Um: Each
Checked & Approved By	: <u>1007.0831</u>		
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2571
 Ensure that grain is along 7.75" length
 Batch No: B31389

BG 07.10.13

(8)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. BG Double check by: _____

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

BG/JP 07/10/25

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

BG/JP 07/10/25

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG/JP 07/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 01/10/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:51:23 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 34367

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/10/26 (8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FX 07/10/29 (8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105008

BR 07-10-29 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/10/30 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST-432

(8) 07/10/30 AB K

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(8) 07/10/30

Job Completion



U 07-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34367
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.140	.440	.440		
B	1.745	1.755		1.750	1.750	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.749	1.749		
E	7.990	8.010		8.005	8.005	8.000	8.001		
F	0.490	0.510		.500	.500	.501	.495		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.504	.504	.504	.504		
J	1.174	1.184		1.179	1.179	1.179	1.180		
K	0.558	0.578		.569	.570	.570	.570		
L	1.174	1.184		1.179	1.179	1.179	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.129	.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		.245	.245	.245	.245		
W	0.115	0.135		.121	.119	.119	.119		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.762	.760	.760	.760		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.633	.633	.633	.633		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.256	.257	.257	.257		
AE	1.375	1.395		1.378	1.376	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.256	.257	.257	.257		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	36/818
Date:	07/10/25

Audited by:	J.F.
Date:	07/10/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	34367
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	57	62	73	84	By	Date
A	0.438	0.443	DT8682	.440	.441	.441	.441		
B	1.745	1.755		1.750	1.751	1.751	1.751		
C	3.495	3.505		3.500	3.501	3.500	3.500		
D	1.745	1.755		1.750	1.751	1.751	1.751		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		.506	.498	.498	.500		
G	0.257	0.262	DT8683	.257	.257	.258	.258		
H	0.375	0.380	DT8684	.377	.377	.376	.376		
I	0.490	0.510		.505	.502	.503	.503		
J	1.174	1.184		1.180	1.180	1.179	1.179		
K	0.558	0.578		.578	.569	.569	.567		
L	1.174	1.184		1.180	1.180	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.495	2.498	2.495	2.500		
O	3.869	3.879		3.874	3.874	3.873	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.246	.250	.250	.250		
S	0.115	0.135		.128	.135	.135	.135		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.962	2.962		
V	0.230	0.250		.245	.246	.246	.246		
W	0.115	0.135		.125	.130	.130	.129		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.350	.350	.350	.350		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.387	1.387	1.387	1.380		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									







Measured by:	JLF
Date:	07/10/25

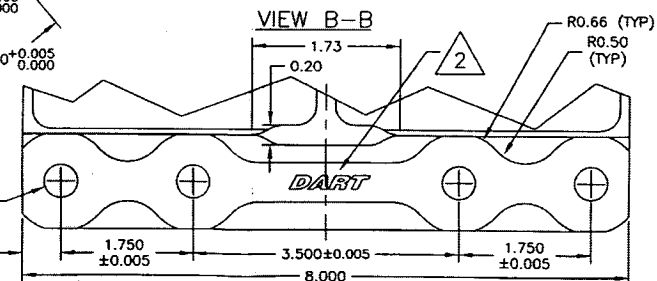
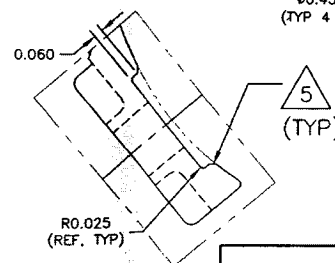
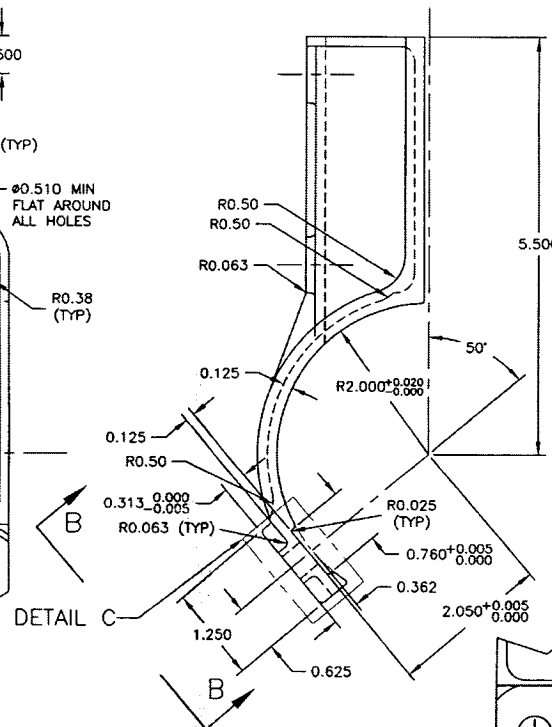
Audited by:	J.F.
Date:	07/10/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	




05.12.06

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |



DETAIL C
SCALE 4:3

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
DS	DRAWN BY PH	
CHECKED 	APPROVED 	DRAWING NO. D2571
DATE 05.07.13		TITLE OUTER FWD SADDLE SCALE 2:3

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